

September-15-14 7:28:31 AM

Page 1

**\*NR2\***

Large Fab	<b>Memo</b>	0.00
Large Fab	1-Bevel end for welding FWD ONLY	
	2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272	
	A/RAluminum Rod <i>M/28956</i>	
	3-Grind End Plate flush	

**Work Order ID 124552**

September-15-14 7:28:32 AM

**\*124552\***

Page 2

Item ID: D350-591-311

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Heli-Access-Step™ LH

Stop

**\*NS2\***

Start Date: 9/15/14 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 9/19/14 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*120\***

QC

Memo

0.00

Quality Control

DAS  
43  
9-89

OCT 07 2014

5x

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

DAS  
43  
9-89

OCT 09 2014

5x

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

(S) \$

14-10-10

# Work Order ID 124552

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**\*124552\***

Page 3

Item ID: D350-591-311

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Heli-Access-Step™ LH

Stop

**\*NS2\***

Start Date: 9/15/14 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 9/19/14 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00							DAS
<b>*150*</b>						<u>5</u>			38
QC	Memo	0.00							9-89 14-10-16
Quality Control									
180		0.00							DAS
<b>*180*</b>	Large Fab					<u>5</u>			OCT 21 2014
Large Fab	Memo	0.00							24
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								9-89
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod <u>12-8756</u>								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

**Work Order ID 124552**

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**\*124552\***

Page 4

Item ID: D350-591-311

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Heli-Access-Step™ LH

Start Date: 9/15/14 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 9/19/14 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00				(B)	GL		DAS 38 9-89 OCT 2 1 2014
200 <b>*200*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				(S)			DAS 38 9-89
210 <b>*210*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				(S)	14-10-21		DAS 38 9-89 OCT 2 1 2014

# Work Order ID 124552

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**\*124552\***

Page 5

Item ID: D350-591-311

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Heli-Access-Step™ LH

Stop

**\*NS2\***

Start Date: 9/15/14

Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 9/19/14

Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

220

White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum

0.00

**\*220\***

Powdercoat

*M 124.808*

Memo

0.00

Powder Coating

START TIME: *10:10*

OVEN TEMPERATURE: *320°*

FINISH TIME: *11:40*

*5 14-10-22*

DAS 34 889

230

Wing Walk as per dwg OSI005 4.4 Batch *11130209*

0.00

**\*230\***

HandFinish

Memo

0.00

Hand Finishing

*x5h4 d 11/10/27*

240

QC3- Inspect Part Finish

0.00

**\*240\***

QC

Memo

0.00

Quality Control

*(5)*

DAS  
38

9-89 OCT 23 2014



**Work Order ID 124552**

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**\*124552\***

Page 7

Item ID: D350-591-311

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step™ LH

Start Date: 9/15/14 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 9/19/14 Req'd Qty: 5.00

**\*5\***

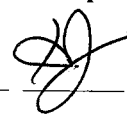
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									

14/11/4 MF  
14-11-04

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Page 1

Work Order ID: 124552

**\*124552\***

Parent Item: D350-591-311

**\*D350-591-311\***

Parent Item Name: Heli-Access-Step™ LH

Start Date: 9/15/14

Required Date: 9/19/14

Start Qty: 5.00

Required Qty: 5.00

## Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3272-1 JLM

IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified

by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No			110	Each	3.0000	1	5			
<b>*D3272-1*</b>									**				
Step													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA003	3							
					123916	2							
					124001	1							
D3067-1		Manufactured	No			110	Each	351.0000	1	5			
<b>*D3067-1*</b>									**				
End Plate													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA003	351							
					101785	67							
					102686	14							
					117776	120							
					119290	150							
D3219-1		Manufactured	No			110	Each	125.0000	2	10			
<b>*D3219-1*</b>									**				
Plate													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA003	125							
					114934	26							
					115339	99							

CPC 14.10.21  
B124551 → 5

CPC 14.10.21  
B117776 → 5

CPC 14.10.21  
B124869 → 10



# Picklist Print

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Page 2

Work Order ID: 124552

**\*124552\***

Parent Item: D350-591-311

**\*D350-591-311\***

Parent Item Name: Heli-Access-Step™ LH

Start Date: 9/15/14

Required Date: 9/19/14

Start Qty: 5.00

Required Qty: 5.00

D3066-1 Manufactured No

180 Each 86.0000 2 10

**\*D3066-1\***

Spacer

**\*\***

*DL 14-10-16*

Location

Loc Qty

Loc Code

WA003

86

106302

7

115868

39

115869

40

MS20600-AD4W4

Purchased No

180 Each 2,253.000 16

80

**\*MS20600-AD4W4\***

Rivets

**\*\***

*DL 14-10-16*

Location

Loc Qty

Loc Code

ST310

2253

125577

215

M128899

2038

D3065-041

Manufactured No

180 Each 12.0000 1

5

**\*D3065-041\***

Step Leg Assembly

**\*\***

*DL 14-10-16*

Location

Loc Qty

Loc Code

WA003

12

102830

6

109447

2

113075

2

123378

2

*124225*

*5*

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Work Order ID: 124552

**\*124552\***

Parent Item: D350-591-311

**\*D350-591-311\***

Parent Item Name: Heli-Access-Step™ LH

Start Date: 9/15/14

Required Date: 9/19/14

Start Qty: 5.00

Required Qty: 5.00

D3067-1

Manufactured No

180 Each

351.0000

1 5

**\*D3067-1\***

End Plate

\*\*

*PC 14-10-21*

Location

Loc Qty

Loc Code

WA003

351

101785

67

102686

14

117776

120

119290

150

AN3-35A

Purchased

No

250

Each

73.0000

2 10

**\*AN3-35A\***

Bolt

DAS

38

9-89

\*\*

*CL 14/10/31*

DAS

31

9-89

Location

Loc Qty

Loc Code

FG

10

122800

10

ST348

63

m129934

63

D3235-1

Manufactured

No

250

Each

283.0000

2 10

**\*D3235-1\***

Mounting Lug

DAS

38

9-89

\*\*

*CL 14/10/31*

Location

Loc Qty

Loc Code

ST519

283

102818

4

105939

17

108670

43

114441

54

116383

100

116384

13

116385

52

DAS

31

9-89

# Picklist Print

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Work Order ID: 124552

**\*124552\***

Parent Item: D350-591-311

**\*D350-591-311\***

Parent Item Name: Heli-Access-Step™ LH

Start Date: 9/15/14

Required Date: 9/19/14

Start Qty: 5.00

Required Qty: 5.00

D3278-041

Manufactured No

250 Each

69.0000

**\*D3278-041\***

DAS  
38  
9-89

Support Assembly

\*\*

CLY/10/31

## Location

## Loc Qty

## Loc Code

ST521

39

102349

1

114169

31

114940

2

121431

5

ST523

30

123337

30

NAS1149D0463J

Purchased

No

250

Each

5,132.000

16 80

**\*NAS1149D0463J\***

WASHER

DAS  
38  
9-89

\*\*

CLY/10/31

## Location

## Loc Qty

## Loc Code

CA

485

M129682

485

ST277

4647

113706

1

16941

8

M126221

20

M127813

6

M127904

16

M128591

44

M128995

1500

M129390

3052

DAS  
31  
9-89

# Picklist Print

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Page 5

Work Order ID: 124552

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step™ LH

**\*124552\***

**\*D350-591-311\***

Start Date: 9/15/14

Required Date: 9/19/14

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0563J

Purchased

No

250

Each

1,791.000

4 20

**\*NAS1149D0563J\***

DAS

38

9-89

Washer

\*\*

CL14/10/31

Location

Loc Qty

Loc Code

GA

125

m125807

125

ST510a

1666

m126319

98

m128257

1568

250

Each

131.0000

2 10

AN5-36A

Purchased

No

**\*AN5-36A\***

DAS

38

9-89

Bolt

\*\*

CL14/10/31

Location

Loc Qty

Loc Code

ST336

131

M126105

1

M127410

7

M127460

23

M130325

100

250

Each

151.0000

2 10

D2618

Manufactured

No

**\*D2618\***

DAS

38

9-89

Bushing

\*\*

CL14/10/30

Location

Loc Qty

Loc Code

ST008A

151

103863

3

114872

1

123045

100

97780

47

DAS

31

9-89

# Picklist Print

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Work Order ID: 124552

**\*124552\***

Parent Item: D350-591-311

**\*D350-591-311\***

Parent Item Name: Heli-Access-Step™ LH

Start Date: 9/15/14

Required Date: 9/19/14

Start Qty: 5.00

Required Qty: 5.00

D2230-3 Manufactured No

250 Each

322.0000

4 20

**\*D2230-3\***

Mounting Lug

DAS  
38  
9-89

Location

Loc Qty

Loc Code

FG	7	
109344	4	
89045	3	
ST519	315	
108668	1	
109344	2	
114151	1	
114921	4	
115583	64	
116378	143	
116379	100	

\*\*

CL 14/10/31

DAS  
31  
9-89

D2856-400 Manufactured No

250 f

196.0000

1.2 6

**\*D2856-400\***

Abrasion Strip 4" Wide (Per Foot)

DAS  
38  
9-89

Location

Loc Qty

Loc Code

ST426	196	
117887	196	

\*\*

CL 14/10/31

DAS  
31  
9-89

\*\*\* cut (2) at 7.20" (D2856-400-720) \*\*\*

MS21042L3 Purchased No

250 Each

2,651.000

2 10

**\*MS21042L3\***

Nut

DAS  
38  
9-89

Location

Loc Qty

Loc Code

ST307	2651	
123900	934	
M127410	11	
M127831	41	
M128401	42	
M128754	1623	

\*\*

CL 14/10/31

DAS  
31  
9-89

September-15-14 7:28:31 AM

Shop Packet Print

Page 6

# Picklist Print

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Page 7

Work Order ID: 124552

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step™ LH

**\*124552\***

**\*D350-591-311\***

Start Date: 9/15/14

Required Date: 9/19/14

Start Qty: 5.00

Required Qty: 5.00

AN4-13A

Purchased

No

250

Each

716.0000

8

40

**\*AN4-13A\***

Bolt

DAS

38

9-89

\*\*

CD 14/10/31

Location

Loc Qty

Loc Code

CA

2

m129682

2

FG

20

122808

20

GA

14

m125709

14

ST345

400

m130325

400

ST515

280

121652

4

m127432

36

m127817

22

m128739

218

DAS

31

9-89

MS21042L5

Purchased

No

250

Each

576.0000

2

10

**\*MS21042L5\***

Nut

DAS

38

9-89

\*\*

CD 14/10/31

Location

Loc Qty

Loc Code

ST307

576

125684

8

m127304

1

m127813

497

m128810

7

m129472

63

DAS

31

9-89

m130358

# Picklist Print

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Work Order ID: 124552

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step™ LH

**\*124552\***

**\*D350-591-311\***

Start Date: 9/15/14

Required Date: 9/19/14

Start Qty: 5.00

Required Qty: 5.00

MS21042L4

Purchased

No

250

Each

4,213.000

8 40

**\*MS21042L4\***

Locknut

\*\*

02/14/10/31

DAS  
31  
9-89

Location

Loc Qty

Loc Code

ST007

12

121444

12

ST307

4201

111827

2

126275

5

m126015

12

m126275

27

m127255

63

m127376

9

m127813

831

m128300

69

m128798

683

m129472

1000

m129934

1500

3

37

DAS  
31  
9-89

NAS1149D0363J

Purchased

No

250

Each

1,518.000

4 20

**\*NAS1149D0363J\***

Washer

DAS  
38  
9-89

Location

Loc Qty

Loc Code

GA

7

124392

7

ST276

5

m123441

5

ST510a

1506

m128429

1506

DAS  
31  
9-89

m130358

**DART**

DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG SCALE NTS	
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**07.06.04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

*[Handwritten signature]*  
*24552*

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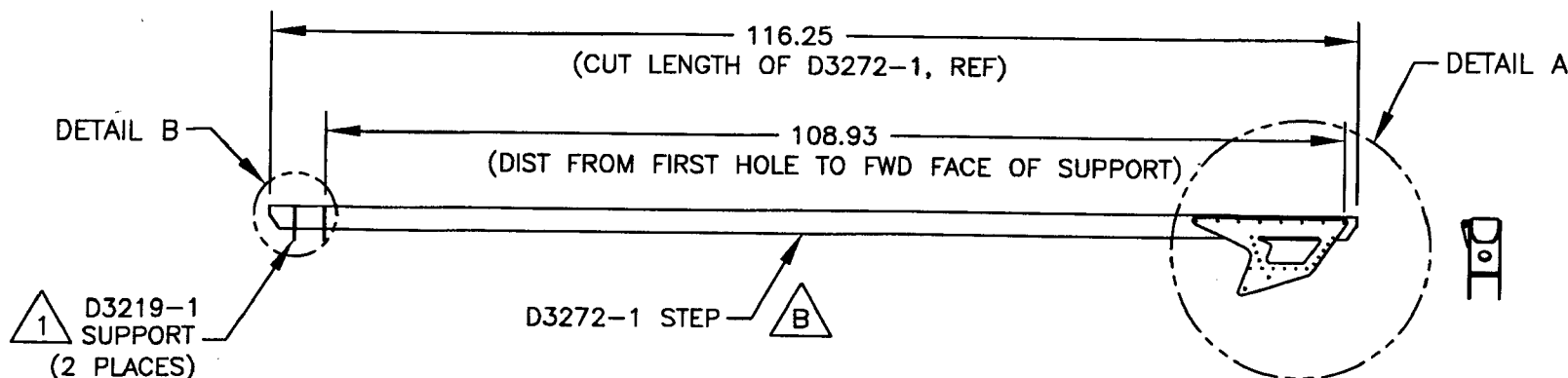


**DART**

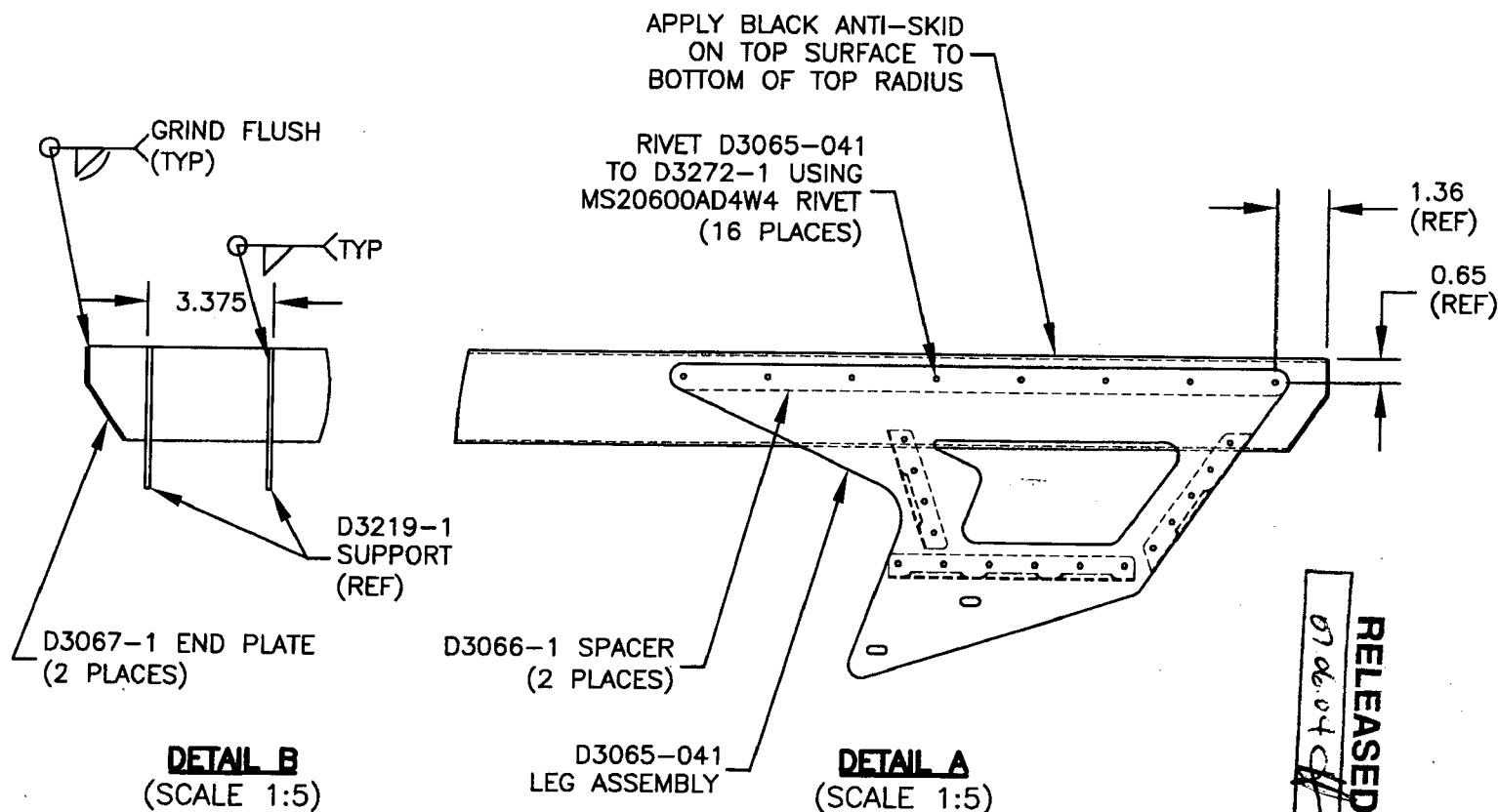
DESIGN	APPROVED	DRAWING NO.	REV. B
CHECKED	APPROVED	D3272	SHEET 2 OF 3
DATE	07.05.18	TITLE	SCALE
		STEP ASSEMBLY, HI LONG	1:20

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

**RELEASED**  
07.06.04



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

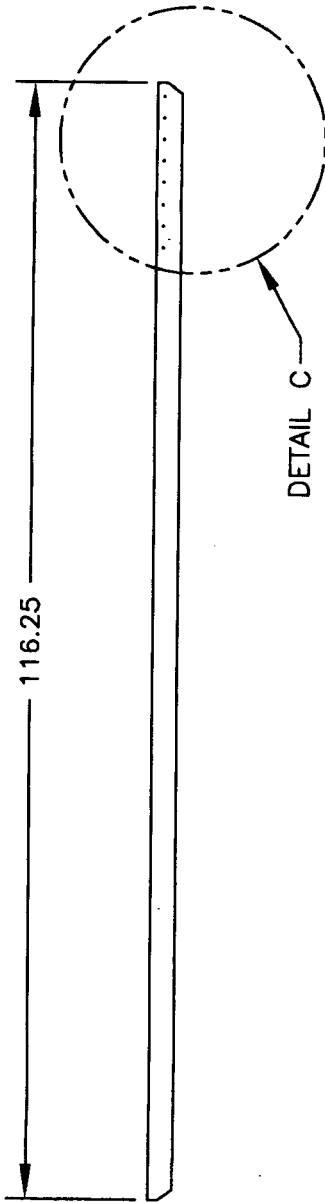




DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

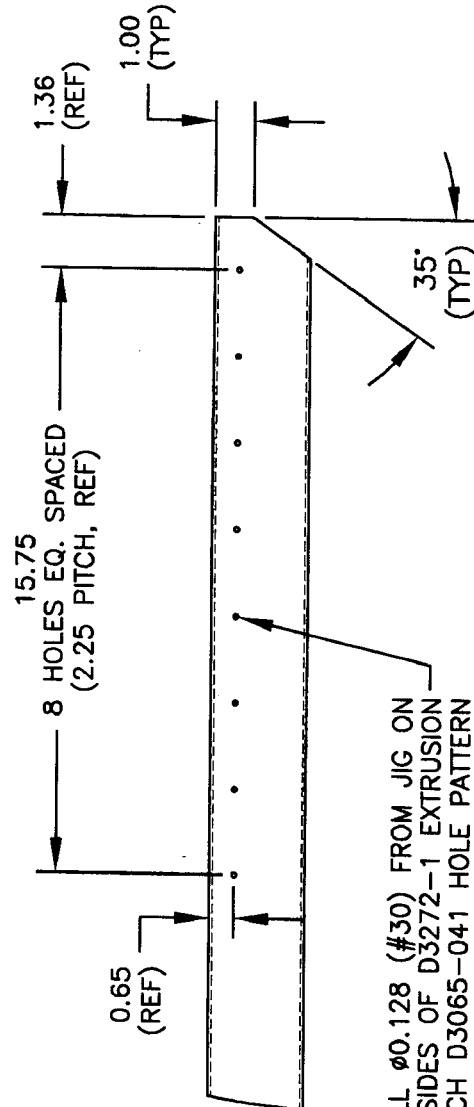
07.06.04 *H*



DETAIL C

**B** **D3272-1 STEP**

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL  $\phi 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	<del>STEP ASSEMBLY (HIGH-LONG, LH)</del>
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2		4	D2230-3	<del>MOUNTING LUG</del>
8	8							D2274	RADIUS BLOCK
						2		D2618	<del>BUSHING</del>
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2		D2856-400-720	<del>ABRASION STRIP</del>
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	<del>D3235-1</del>	<del>MOUNTING LUG</del>
						1	1	<del>D3278-041</del>	<del>SUPPORT ASSEMBLY</del>
2	2	2	2	2	2	2	2	AN3-35A	<del>BOLT</del>
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	<del>BOLT</del>
						2	2	AN5-36A	<del>BOLT</del>
4	4	4	4	4	4	4	4	AN960JD10	<del>WASHER</del>
20	20	12	12	12	12	16	16	AN960JD416	<del>WASHER</del>
						4	4	AN960JD516	<del>WASHER</del>
2	2	2	2	2	2	2	2	MS21042L3	<del>NUT</del>
10	10	6	6	6	6	8	8	MS21042L4	<del>NUT</del>
						2	2	MS21042L5	<del>NUT</del>
						1	1	DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

Work Order ID 124552

September-15-14 7:28:31 AM

\*124552\*

Item ID: D350-591-311

Revision ID:

Item Name: Heli-Access-Step™ LH

Start Date: 9/15/14 Start Qty: 5.00

Required Date: 9/19/14 Req'd Qty: 5.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3272

Rev B

0.00

0.00

100

Document Control

DOCUMENT CONTROL

\*100\*

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

0.00

0.00

110

Large Fab

\*110\*

Large Fab

Large Fab

Memo

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 &amp; Dwg

D3272

A/RAluminum Rod

3-Grind End Plate flush

OCT 07 2014

DAS

24

9-89